



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE117-80168 W2-1
Job Sheet 185119



Part No: RBE117-80168 W2-1

Job Qty: 4 ea

Part Name: Tool 1



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-80168 W2 Rev. 0 IPP Rev. A 18.09.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/30/18	0.00	0.00	Start Up Machining-2		
110	CNC Lathe	4 pcs		11/30/18	0.00	1.00	MORI SL-154		
120	QC	4 pcs		11/30/18	0.00	0.00	QC2 Machining-4		
130	QC	4 pcs		11/30/18	0.00	0.00	QC8 Machining-4		
150	Outsource	4 pcs		11/30/18	0.00	0.00	Outsource4		
160	Packaging	4 pcs		11/30/18	0.00	0.00	Packaging2		
170	QC	4 pcs		11/30/18	0.00	0.00	QC6		
180	Packaging	4 pcs		11/30/18	0.00	0.00	Packaging3-1		
190	QC21-SA	4 Ea		11/30/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FC430 FOLIO REV: _____ DWG REV: _____ 2-Debur DEC 18 2018
Descriptions: 150 - -Issue P/O to GROUPE ALTECH; PO 041987 -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2
CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required

GA133

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.000	Round Bar 1.00"	.9600 ft (.24 ea)	90-Start up Operation	5127980

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.000	1	42	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartee.com
www.dartaerospace.com

Plex 10/23/18 7:54 AM Dart.lajeunesse.marie

Container No: S135219



Part: RBE117-80168 W2-1

Job No: 185119

Serial No/Batch: S135219

Revision: 0

Inspector:

Exp Date:

Instructions:

Date: 12/06/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

SHOP COPY

RETURN TO
ENGINEERING

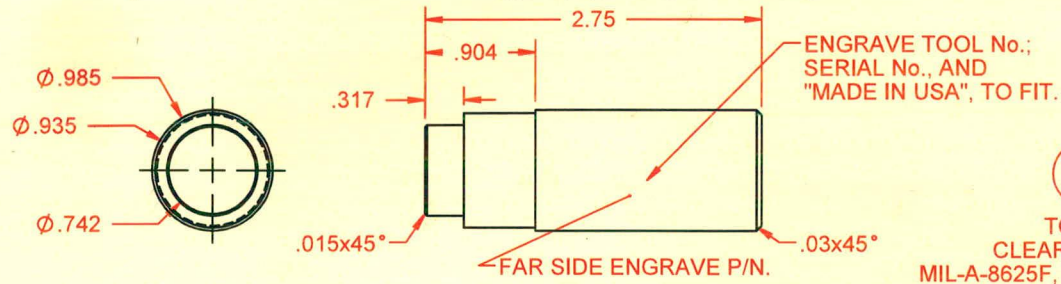
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

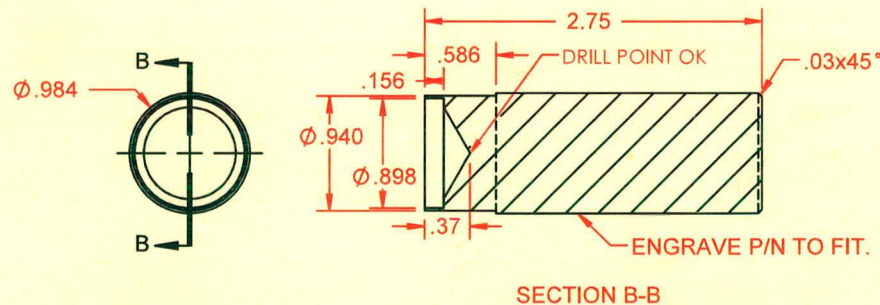
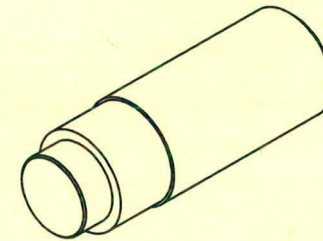
NO. 185719 MLJ
181023

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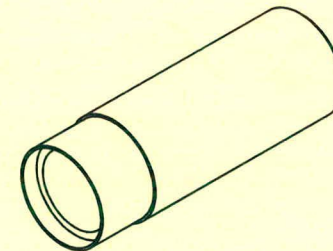
REV	DESCRIPTION	REVISIONS		
		DATE	INITIAL	APPROVED
-	-	-	-	-



-1
TOOL 1
CLEAR ANODIZE
MIL-A-8625F, TYPE 1, CLASS 1



-2
TOOL 2



SECTION B-B

ASSY QTY	QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-1	1	TOOL 1	6061	$\phi 1 \times 2-7/8$
			-2	1	TOOL 2	4140 Q&T	$\phi 1 \times 2-7/8$

RED BARN MACHINE	
TITLE M/R HUB MOUNTING TOOL	
DWG NO. RBE117-80168 W2	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX $\pm .005$.XX $\pm .01$ X $\pm .1$	FRACTIONS $\pm 1/32$ ANGLES $\pm 5^\circ$
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-26-09
SHEET 1 of 1	
DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT: SEE TOOL FINISH SPEC: EUROCOPTER 145 USED ON MODEL:	



Dart Aerospace Ltd.
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Hawkesbury, ON
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Tel (613) 632-5200

PURCHASE ORDER **PO041987**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041987
PO Date: 12/7/18
Due Date: 12/18/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185127	RBE117-12010W66-1	Ring 1 -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/18/18	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00
2	185119	RBE117-80168 W2-1	Tool 1 -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/18/18	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00

4 X

DEC 17 2018

4 X

DEC 17 2018

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PURCHASE ORDER

PO041987

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	184951	RBW6405G00332-3G-7	Slide Seat -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	12/18/18	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00
							4 X	DEC 17 2018			
4	184948	RBW6405G00332-3G-11	Pointer -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	12/18/18	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00
							4 X	DEC 17 2018			
5	185128	RBE117-12010W66-3	Ring 2 -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/18/18	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00
							4 X	DEC 17 2018			
Grand Total:										\$120.00	



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PURCHASE ORDER PO041987

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/12/18 12:33 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(015176-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015176 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
11-Dec-2018		Aman			041987 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
1	RBE117-12010W66-1 ✓ Rev.	RBE117-12010W66-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4 ✓	0	0	0	
2	RBE117-80168W2-1 ✓ Rev.	RBE117-80168W2-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4 ✓	0	0	0	D 3 9
3	RBW6405G00332-3G-7 ✓ Rev.	RBW6405G00332-3G-7 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4 ✓	0	0	0	
4	RBW6405G00332-3G-11 ✓ Rev.	RBW6405G00332-3G-11 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4 ✓	0	0	0	
5	RBE117-12010W66-3 ✓ Rev.	RBE117-12010W66-3 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4 ✓	0	0	0	

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

